

Date: Friday, 16/05/2008 8:45:37 AM
 User: Julie Lecocq

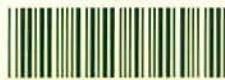
Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 39315		Part Number	: D22301		
Estimate Number	: 10255		Drawing Number	: D2230 REV F		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/05/2008 S.O. No. :		Drawing Revision	: F		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 30/05/2008 Qty: 200 Um: Each		
Previous Run	: 39137					
Written By	:					
Checked & Approved By	: <u>JUL 08.5.16</u>					
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Extrusion Batch: <u>B 33310</u>	<u>108/05/20 (300)</u>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch:	<u>cut at Metec</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per lot D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling	<u>Issue P.O 6387 Metec</u> <u>Machine per drug D2230 Rev.F</u> <u>108/05/20 (300)</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Receive & inspect for transit damage Ensure C/C attached	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>108/05/20 (85)</u>
5.0	QC5	SECOND CHECK	
		Comment: SECOND CHECK	<u>108/05/20 (85)</u> <u>counts</u>
			<u>Inspect level 5</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 39315

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING



HAND FINISHING RESOURCE #1

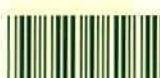


Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

20/05/08-05-29 (85)

7.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/28 (85) center

8.0 POWDER COATING



POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 7:10

OVEN TEMPERATURE: 320°

FINISH TIME: 7:40

(85)

08-05-30

9.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



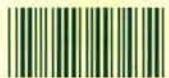
Comment: INSPECT POWDER COAT

08-05-30 (85)

10.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/05/30 85

11.0 QC21



FINAL INSPECTION/W/O RELEASE



08/05/30 (85)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/05/30

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39315
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

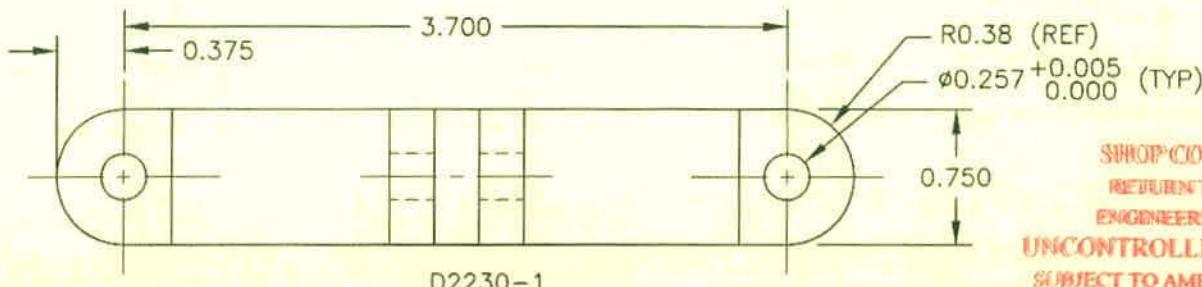
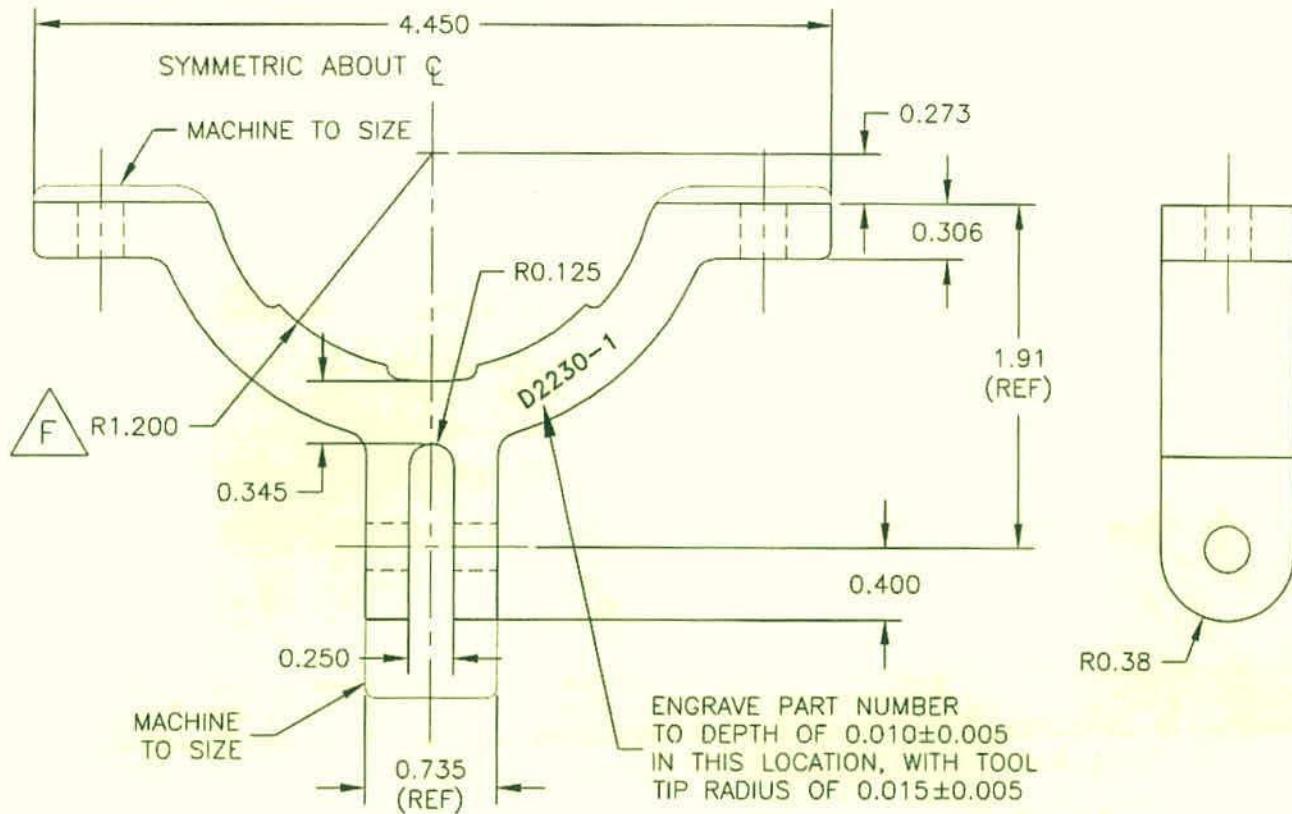
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	++

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		TITLE MOUNTING LUG
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

17.12.21 DS

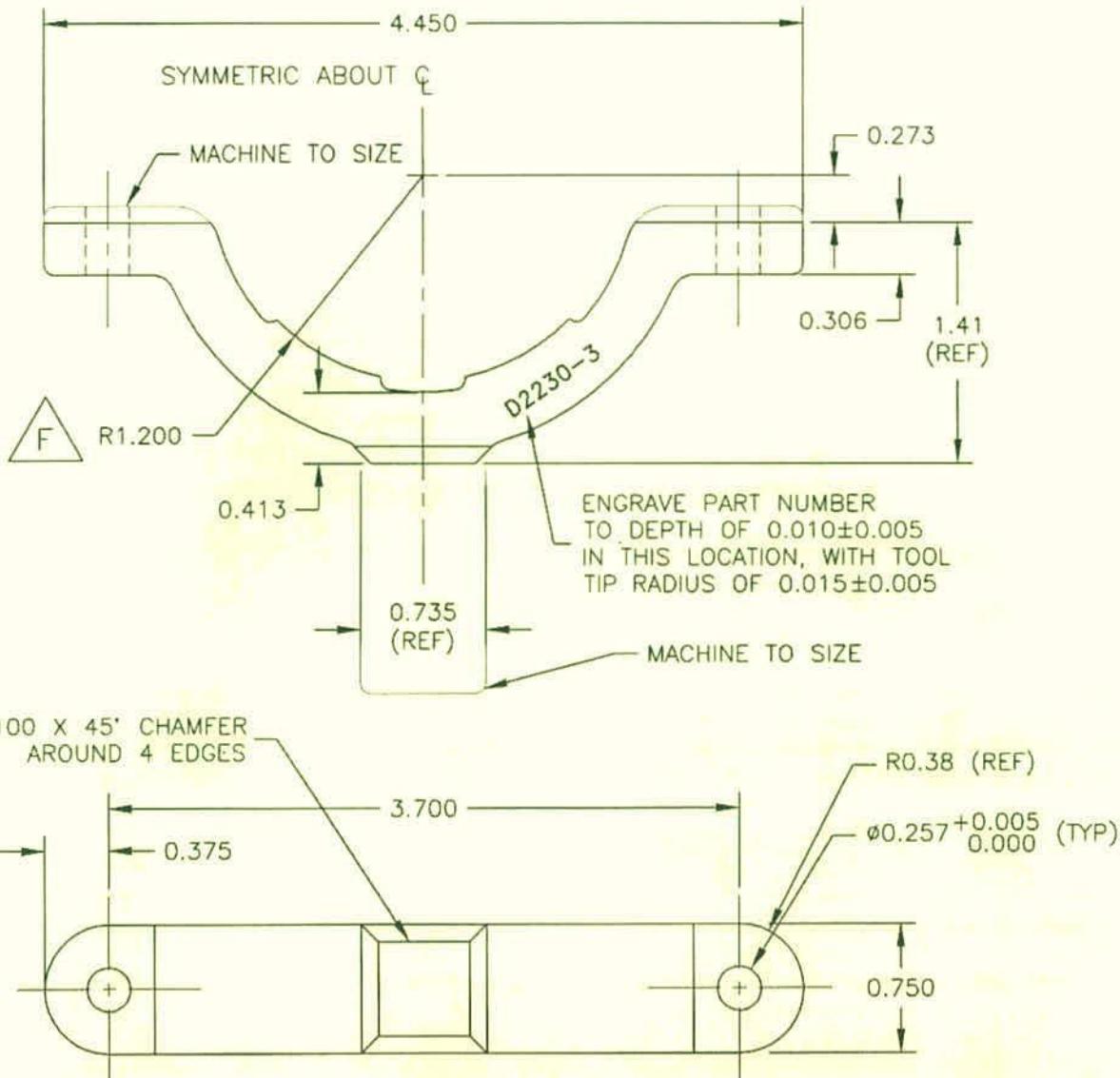


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39315

DARTCOPY ISSUED
TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE	99.12.13	REV. F SHEET 2 OF 2 TITLE MOUNTING LUG SCALE 1:1

RELEASED
19.12.21 DS**SHOP COPY****RETURN TO****ENGINEERING****UNCONTROLLED COPY****SUBJECT TO AMENDMENT****WITHOUT NOTICE****WORK ORDER****NO. 39315**



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
85	D2230-1	Mounting Lug B39315	6387
MATERIAL: supplied by DART D2423 B33310			

We hereby certify that the above parts were made in conformance with applicable drawings.

Denise Robinson
Denise Robinson

Vankleek Hill, May 29, 2008

